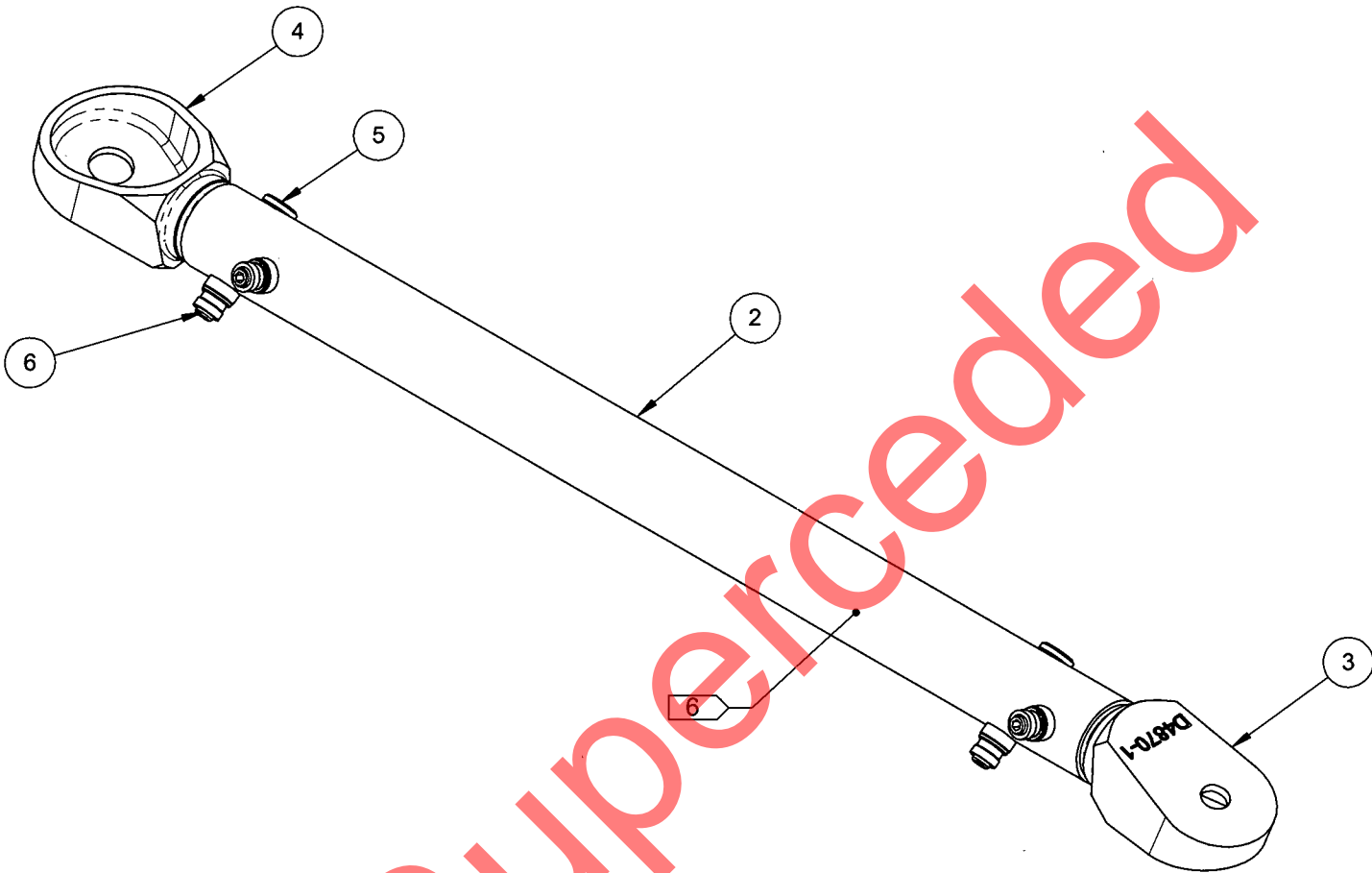


ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4866-041	LEG ASSEMBLY, AFT
2	1	D4866-1	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

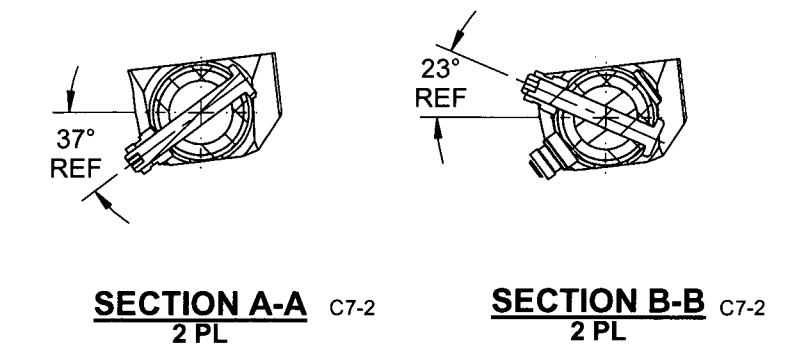
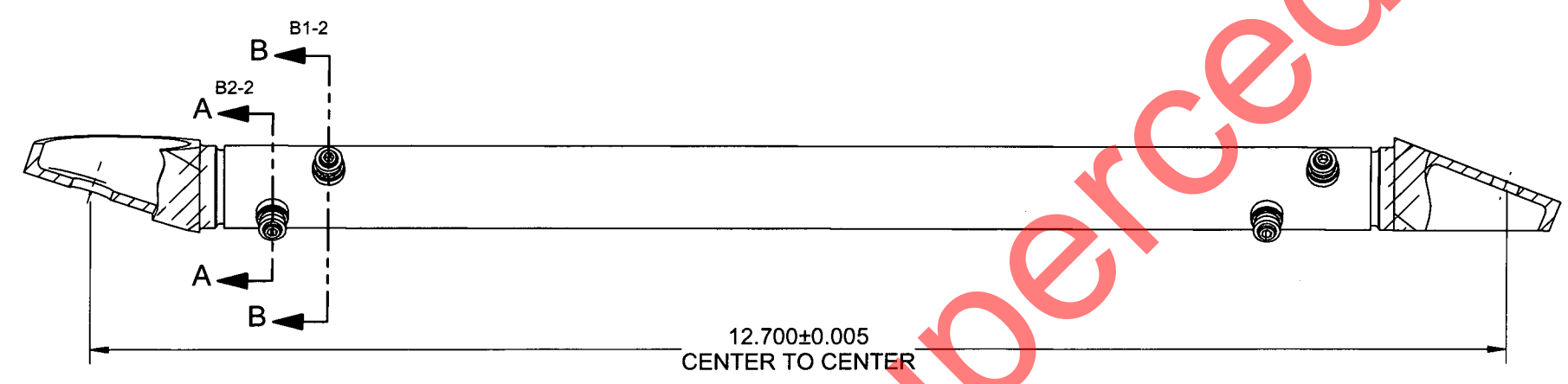
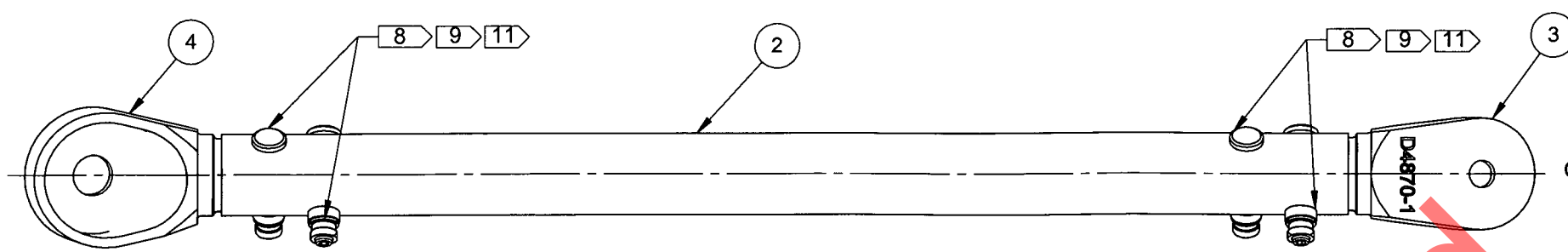


D4866-041 LEG ASSEMBLY, AFT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.76 lbs
 - 8) ALIGN PILOT HOLES IN D4866-1 WITH PILOT HOLES IN D4870-1 & D4870-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9962
 - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9962
 - 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4866	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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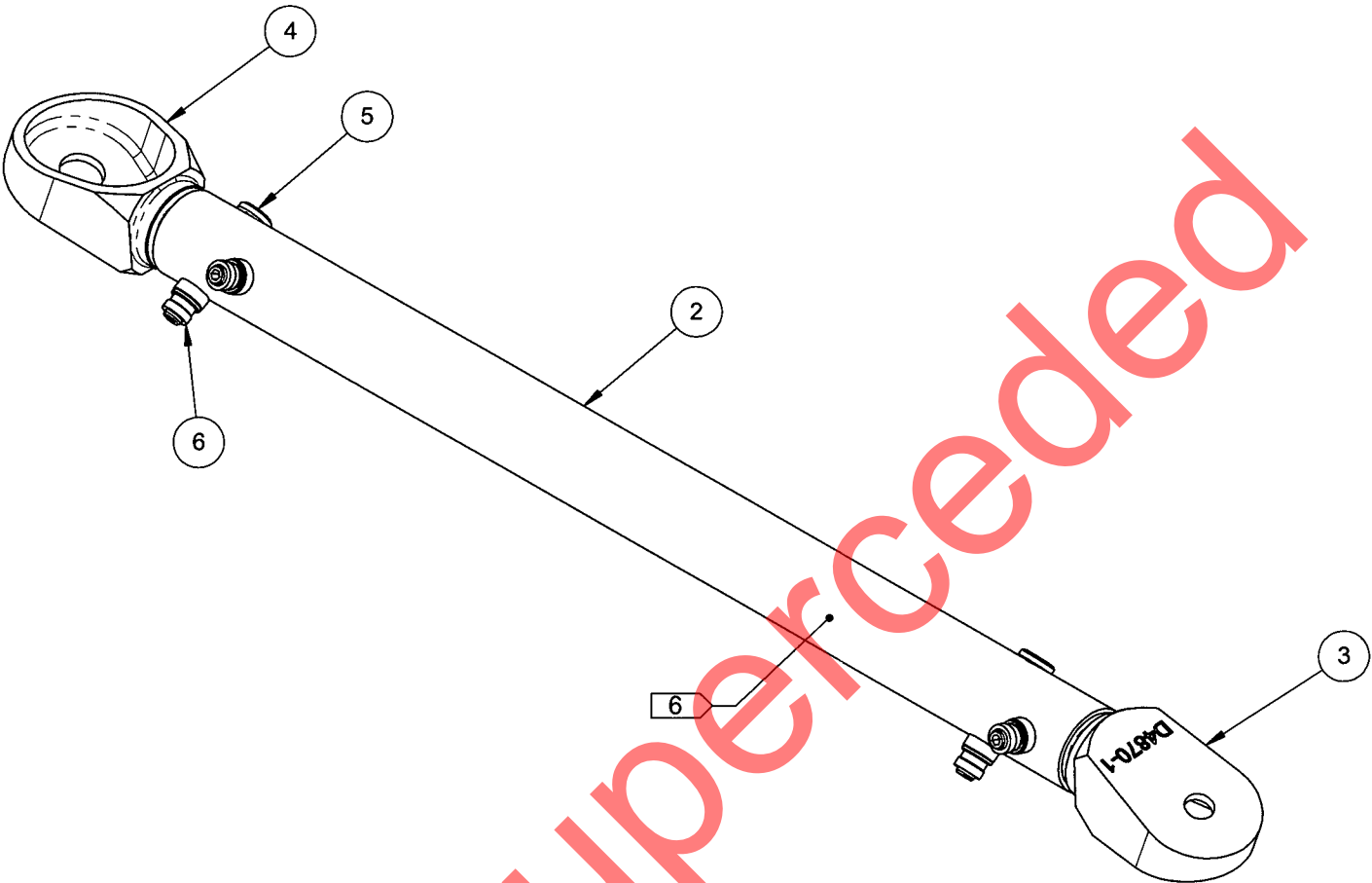


D4866-041 LEG ASSEMBLY, AFT
AUXILIARY VIEW

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4866	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4866-042	LEG ASSEMBLY, AFT
2	1	D4866-2	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4866-042 LEG ASSEMBLY, AFT

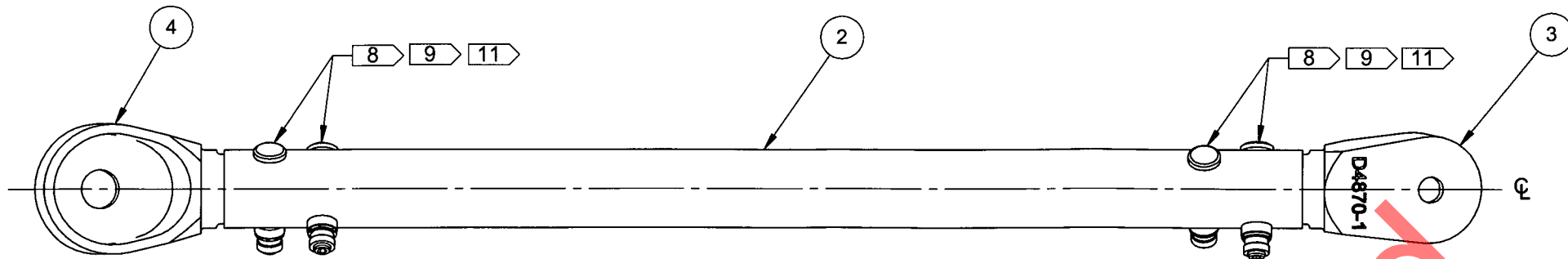
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.76 lbs
 - 8) ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 & D4870-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9963
 - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9963
 - 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	HS	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D4866	SHEET 3 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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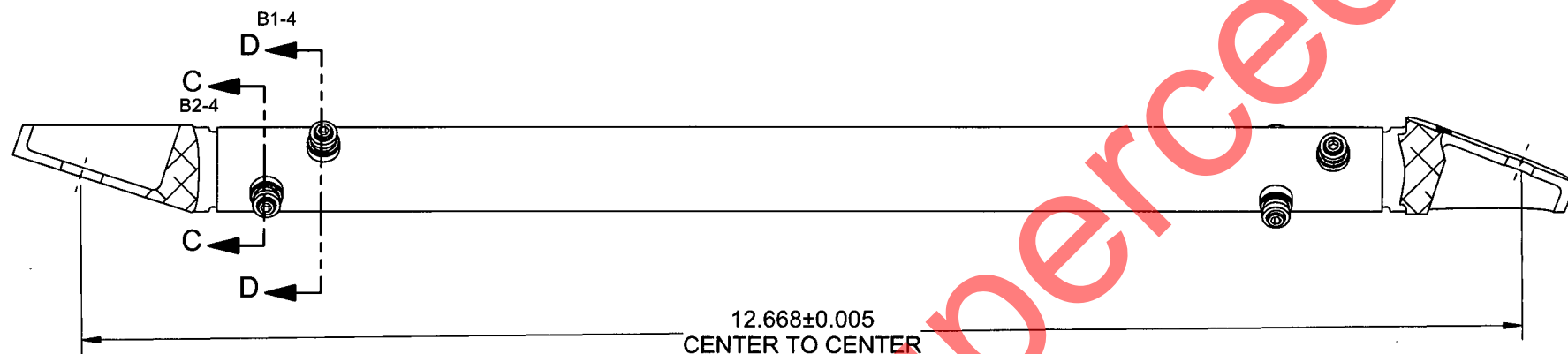
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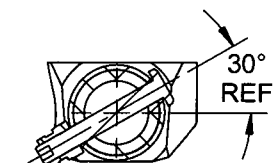
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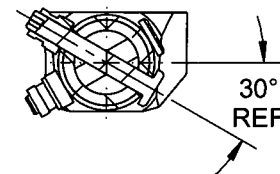


B

B



SECTION C-C C7-4
2 PL



SECTION D-D C7-4
2 PL

**D4866-042 LEG ASSEMBLY, AFT
AUXILIARY VIEW**

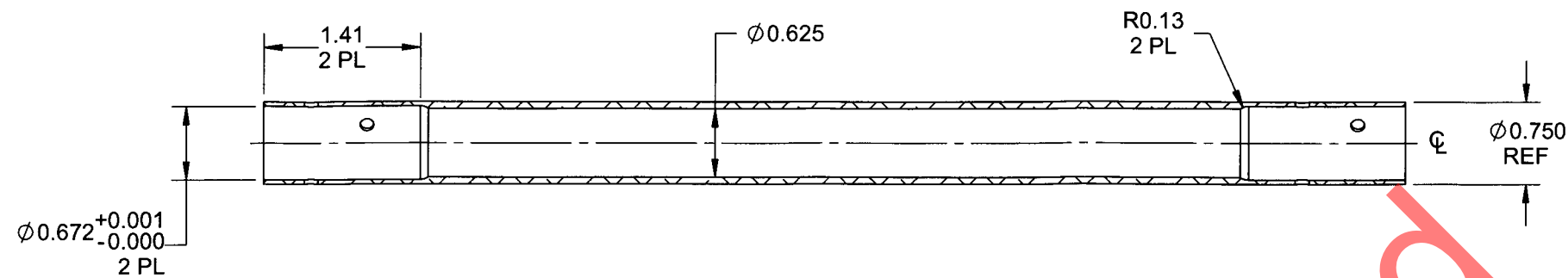
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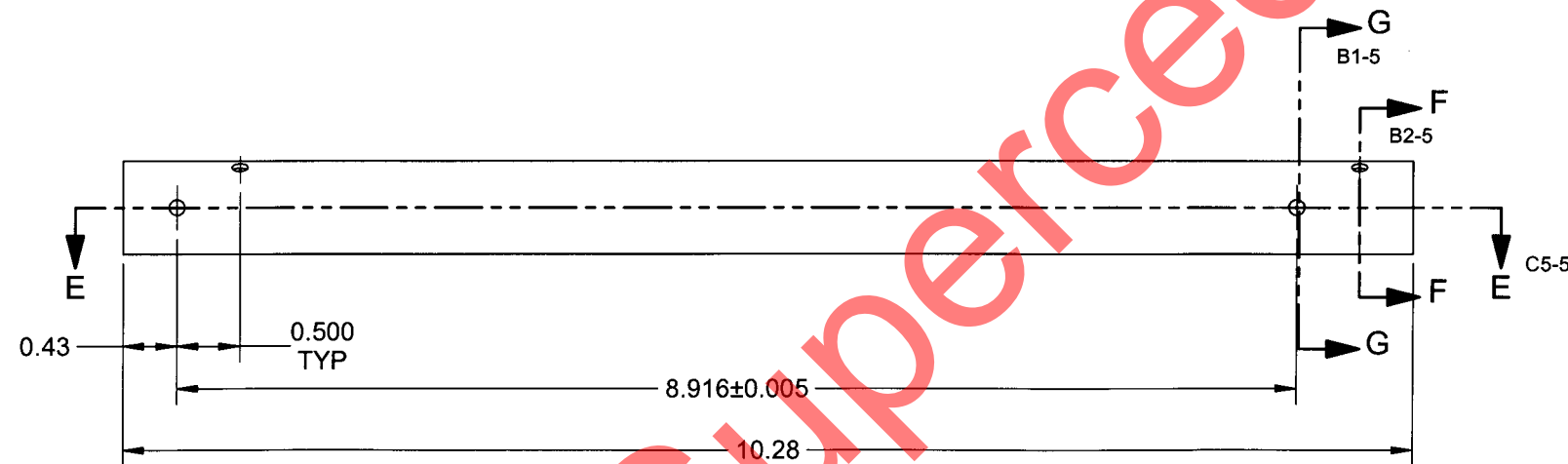
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO. D4866	REV. A
MFG. APPR.	JLM	SHEET 4 OF 6	
APPROVED	HS	TITLE	SCALE
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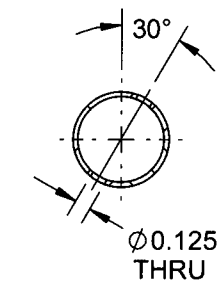
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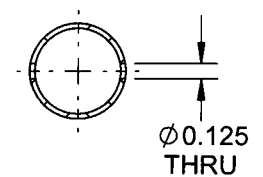
SECTION E-E B3-5



D4866-1 STRUT



SECTION F-F C4-5
2 PL



SECTION G-G C4-5
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.36 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4866	SHEET 5 OF 6
APPROVED	HS	TITLE	SCALE
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